

Date: Tuesday, 17/03/2009 10:35:39 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : DOUBLER
<b>Job Number</b> : 46538	
<b>Estimate Number</b> : 12428	
<b>P.O. Number</b> :	<b>Part Number</b> : D35061
<b>This Issue</b> : 17/03/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3506 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 41605	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 20/03/2009 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.03.17</u>	
<b>Comment</b> : Est Rev:A New Issue 06-05-31 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M6061T6S100	6061-T6 .100 Sheet
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**Comment:** Qty.: 0.0082 sf(s)/Unit Total: 0.1638 sf(s)  
 6061-T6 .100 Sheet  
 (M6061T6S0100)  
 Batch: ~~102201~~ 102201

*ml* 09 03 17 (20)

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3506  
 Dwg Rev: A  
 Prog Rev: A

2-Deburr if necessary

*ml* 09 03 17 (20)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*ml* 09 03 17

(20)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1  
 Machine as per Folio FA640 and Dwg D3506

*SP* 09/03/17 (20)

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

*SP* 09/03/17 (20)

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 46538

Part Number: D35061

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

*Handwritten:* 09-03-18 (20)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1  
C'sink as per Dwg D3506(On Flat side)

*Handwritten:* FF 09-03-18 (20)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Handwritten:* 09/03/18 (20) center

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
Chemical Conversion Coat as per QSI 005 4.1

*Handwritten:* LMD / F/L

*Handwritten:* X20 09/03/18

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*Handwritten:* 09-08-18 X(20)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: *Handwritten:* 51108

*Handwritten:* C.Y. 09/03/19 (20)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*Handwritten:* 09/03/19

Job Completion



*Handwritten:* C.Y. 09/03/19

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 46538
<b>Description:</b> Doubler		<b>Part Number:</b> D3506-1
<b>Inspection Dwg:</b> D3506	<b>Rev:</b> A	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	0.128	✓		VERN	
Ø0.404	+0.006/-0.001	0.404	✓		VERN	
0.750	+/-0.010	0.753	✓		VERN	
1.500	+/-0.010	1.502	✓		VERN	
0.375	+/-0.010	0.378	✓		VERN	
0.750	+/-0.010	0.750	✓		VERN	
0.250	+/-0.010	0.252	✓		VERN	
0.098	+/-0.010	0.097	✓		VERN	

<b>Measured by:</b> <i>mm. mm</i>	<b>Audited by:</b> <i>[Signature]</i>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 09.03.17	<b>Date:</b> 04.03.17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.09	New Issue	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

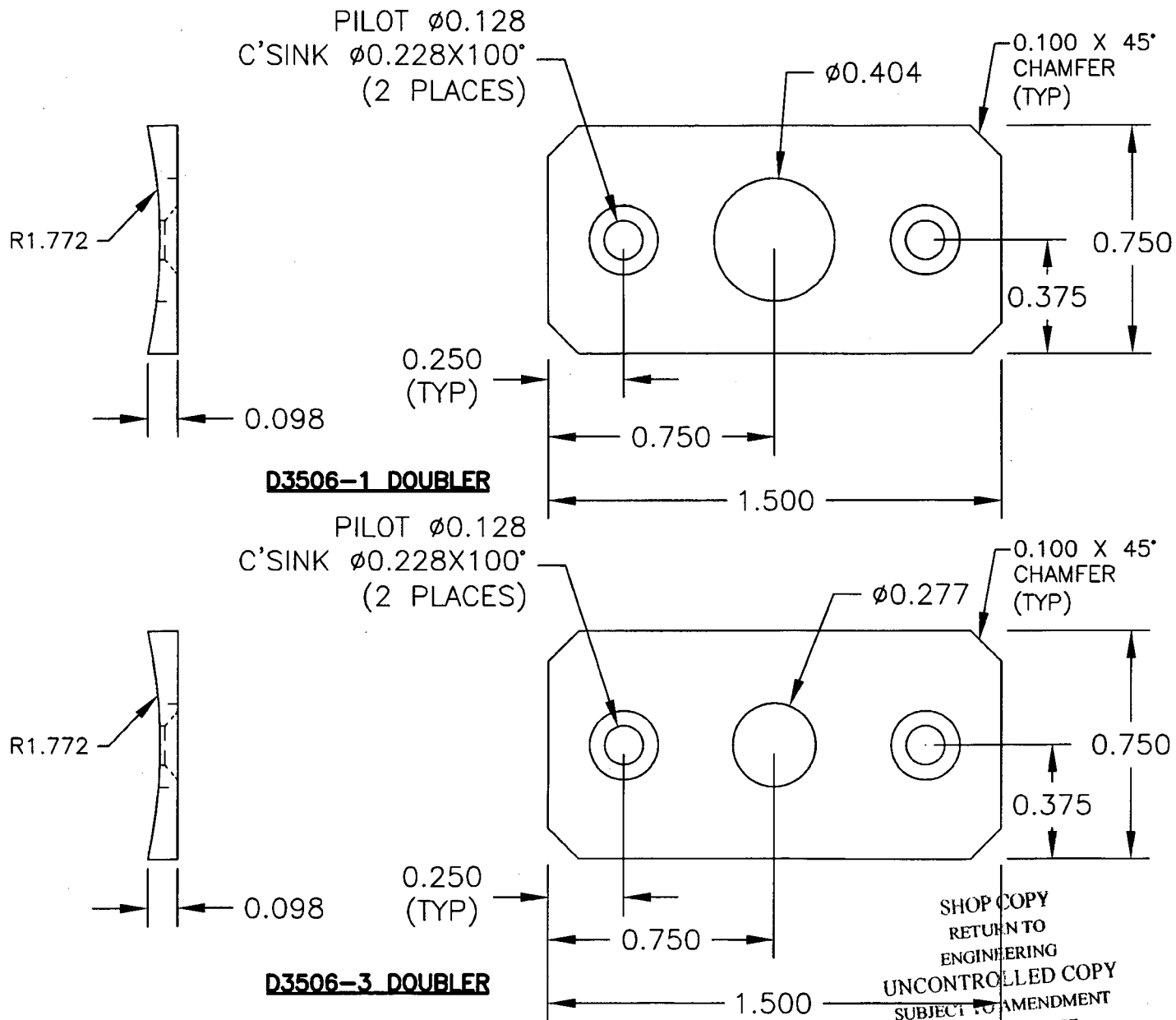
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED JH	APPROVED JH	DRAWING NO. D3506	REV. A SHEET 1 OF 1
DATE 06.04.21		TITLE DOUBLER	SCALE 2:1
A	06.04.21	NEW ISSUE	

**D3506-1/-3 DOUBLER**

- 1) MATERIAL: 6061-T6/T651 ALUMINUM PER QQ-A-250/11 (0.100 THICK) (REF DART MATERIAL SPEC M6061T6S.100)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
#6538

**RELEASED**  
06.10.03 PM  
PER ELM #361

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries